

Work Order ID 92793

November-08-12 11:45:24 AM

\*92793\*

Page 1

Item ID: D212-664-101

Revision ID:

Item Name: Crosstube Fwd High

Start Date: 11/08/12 Start Qty: 1.00

Required Date: 11/08/12 Req'd Qty: 1.00

Reference: Falcon return - scrap

Approvals: Process Plan:    Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_

Accept

\*N900040100\*

Setup

Start

\*NS1\*

Stop

\*NS2\*

Cust Item ID:

Customer:

Run

Start

\*NR1\*

Stop

\*NR2\*

Sequence ID/ Work Center ID	Operation Description	Tooling:	Date:	Run	Start	Stop	Insp. Stamp
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Draw Nbr	Revision Nbr	SPC (Y/N):	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number
----------	--------------	------------	----------------------	---------	--------	--------------	---------------	---------------	------------------

D212-664-141 Rev D (DEO)

250 QC4- 100% Inspect kits for completeness

0.00

QC	Memo	0.00	_____	_____	_____	_____	_____
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Quality Control  
inspect Falcon return  
D212-664-101 B72971  
scrap tube

*Tube given to eng.* 8/12/08

270 QC21- Final Inspection - Work Order Release 0.00

QC	Memo	0.00	_____	_____	_____	_____	_____
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Quality Control

*U 12.11.09*

NCR: Yes / No

DQA: Date: , ,

## **WORK ORDER NON-COMPLIANCE / UPDATE**

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order: _____			DISPOSITION			AGAINST DEPARTMENT/PROCESS					
			Rework Scrap Use-as-is Work Order Update	Skid-tube Machining Thermoforming Large Fab	Crosstube Small Fab Finishing Composite	Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier	Engineering Quality Other				
Part No. _____											
NCR No. _____											
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data											
Equip/Tooling											
Operator											
Material											
Setup											
Other											
Process											
Supplier											
Training											
Unapproved											
FAULT CATEGORY											
Landing Gear	General										
	Bending	Bend	Grain	Ovalized	Pressure/Forced						
	Centre Not Concentric to O/S	BOM/Route	Hardware	Over/Under tolerance	Temperature/Cure						
	Cracks	Broken/Damaged	Inspection Incomplete	Part Incorrect	Weld						
	Crushed/Crimped.	Burrs	Instructions Incomplete/Unclear	Part Lost/Missing	Wrong Stock Pulled						
	Cuffs	Contamination	Maintenance	Part Moved							
	Heat Treat	Countersink	Mislabeled	Positioned Wrong							
	Inspection Strip in Tube	Cut Too Short	Misread	Power Loss/Surge							
	Ripples in Bend	Drill Holes	Offset								
	Torque Waves in Extrusion	Drawing	Out of Calibration								
	Turning Sequence	Finish	Out of Sequence								
	Wave/Twist in Tube	Folio	Outside Dimensions								

# Picklist Print

November-08-12 11:45:24 AM

Page 1

Work Order ID: 92793

Parent Item: D212-664-101

Start Date: 11/08/12

Required Date: 11/08/12

Parent Item Name: Crosstube Fwd High

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:E04.02.16ReformatKJ/DS

IPP Rev:F 06-03-29 Remove Coments on Pick List JLM

IPP Rev:G 07-04-30 As per Rev C JLM

IPP Rev:H 11.04.26 inspection

strip ecn 11-549 EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D212-664-101 Crosstube Fwd High		Manufactured	No				Each	7.0000		1			

	<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
	FG	3	
	86982	1	
	88432	1	
	88433	1	
	FG103	3	
	89269	1	
	90580	1	
	92451	1	
	Return2012	1	
	67351	1	

*7297*

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NCR: Yes / No

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order: _____			DISPOSITION		AGAINST DEPARTMENT/PROCESS					
Part No. _____	Rework <input type="checkbox"/>	Scrap <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>				
NCR No. _____	Use-as-is <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>	Quality <input type="checkbox"/>				
	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Composite <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Other <input type="checkbox"/>				
	Work Order Update <input type="checkbox"/>	Large Fab <input type="checkbox"/>		Supplier <input type="checkbox"/>						
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector	
Doc/Data										
Equip/Tooling										
Operator										
Material										
Setup										
Other										
Process										
Supplier										
Training										
Unapproved										
FAULT CATEGORY										
<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped. <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube				<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabelled <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions						
				<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Other						

91793

Page 1

**Work Order ID 72971**

Tuesday, August 23, 2011 8:11:58 AM



Item ID: D212-664-101

Accept

Setup Start



Revision ID:

Item Name: Crosstube Fwd

Stop



Start Date: 8/23/2011 Start Qty: 1.00



Required Date: 9/7/2011 Req'd Qty: 1.00



Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description
--------------------------------	--------------------------

Draw Nbr	Revision Nbr
D212-664-141	Rev D (DEO)

100



## DOCUMENT CONTROL

DC

Document Control

Memo

Photocopy bluefile and create labels as per PPP D212-664-101 CHG005

0.00

0.00

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	--------------	---------------	---------------	------------------	----------------

110

Pick Kit  
Packaging

Packaging

Memo

0.00

0.00

SAP 11-09-14

120



## BENDING MACHINE - CROSSTUBES

CNC Bend 2

CNC Alpha 160 Bender

Memo

0.00

0.00

SAP 11-09-14

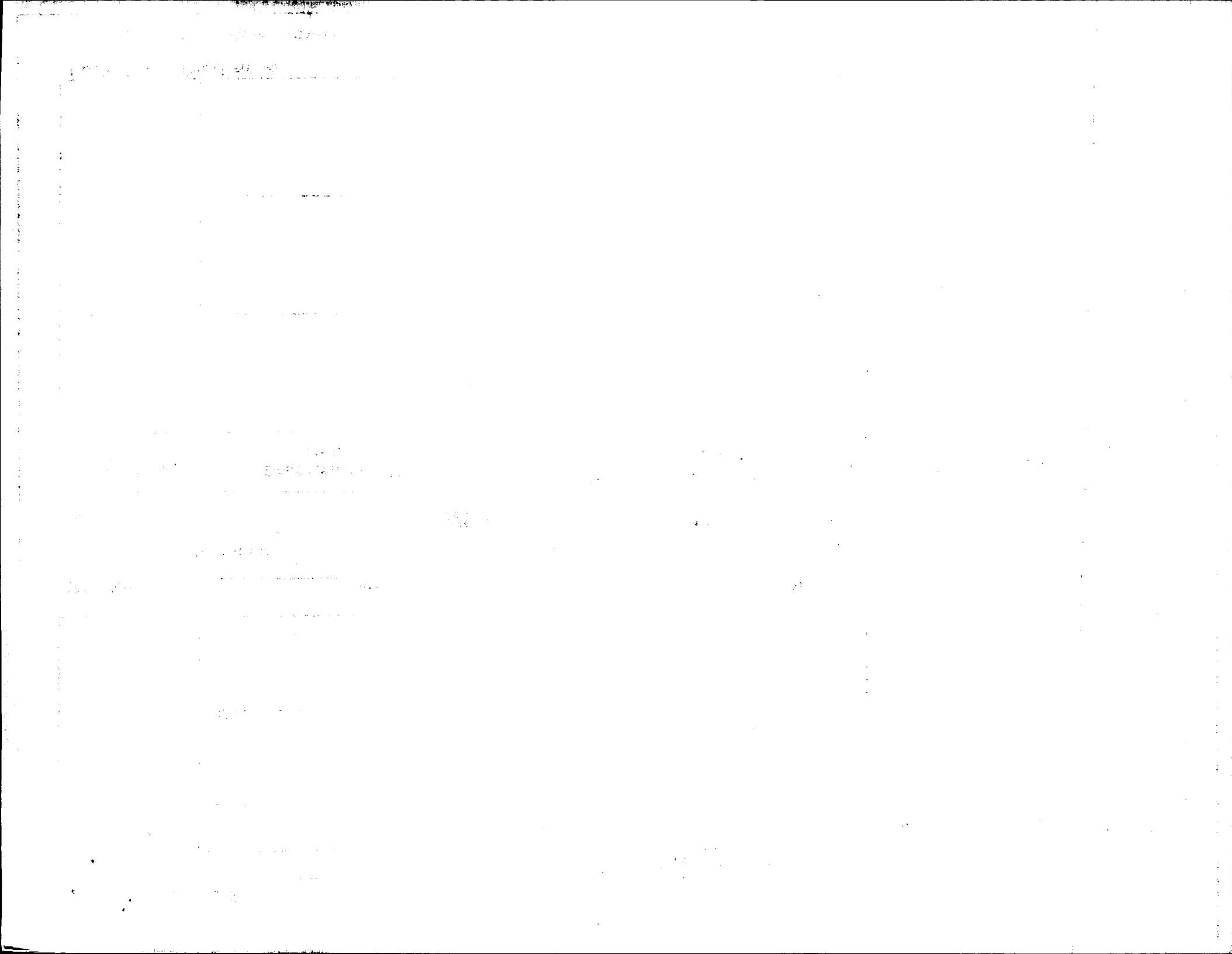
Folio D212-664-101

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date &amp; initial all entries



**Work Order ID 72971**

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Item ID: D212-664-101

Accept



Setup Start



Revision ID:

Item Name: Crosstube Fwd

Stop



Start Date: 8/23/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 9/7/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

QC15- Crosstube Dimensional Check

0.00

Sulostef

0.00



QC

Quality Control

140

Crosstubes

0.00



Crosstubes

Memo

0.00

1-Drill pilot holes in tube as per Dwg D212-664-141 using drill Jig DT8548 &amp; DT8549, using drill table DT8577, set-up towers in hole #7 as per QSI 10

2-Ream hole to finish size in tube as per Dwg D212-664-141 using drill Jig DT8548 &amp; DT8549. Check dimensions between holes, both sides on both cuffs, to ensure alignment with saddle holes.

3-Scribe part # and batch # using vibrating stylus as per Dwg D212-664-141

4-Deburr &amp; Inspect for surface damage. Repair damage within limits as per Dwg D212-664-141

0.00

JW

11-09-14

11-09-15

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Work Order ID 72971**

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Item ID: D212-664-101

Accept



Setup Start



Revision ID:

Item Name: Crosstube Fwd

Stop



Start Date: 8/23/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 9/7/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

**Sequence ID/  
Work Center ID****Operation  
Description**Set Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

150

Crosstubes Chemical Conversion

0.00

MO/SD

H-09-15



HandFXtube

Memo

0.00

Hand Finishing Crosstubes

Chemical Conversion Coat within 24 hours of bending and drilling

160

QC5- Inspect part completeness to step on W/O

0.00



QC

Quality Control

Memo

0.00

Sulowicz

(tc)

170

Outsource process - NDT per QSI038 4.1

0.00



Outsource2

Outsource process - NDT

Memo

0.00

Liquid Penetrant Inspection as per QSI 038  
 Issue P/O: 14914  
 LPI as per ASTM 141 Level 2  
 Attach copy of NDT results to work order

H-09-16

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Work Order ID 72971**

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Item ID: D212-664-101

Accept



Setup Start



Revision ID:

Item Name: Crosstube Fwd

Stop



Start Date: 8/23/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 9/7/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

**Sequence ID/  
Work Center ID****Operation  
Description****Set Up/  
Run Hours****Tool ID****Tool #****Plan  
Code****Accept  
Qty****Reject  
Qty****Reject  
Number****Insp.  
Stamp**

180

Receive & Inspect for Damage & Mat'l Certs  
Packaging

0.00

Packaging

Memo

0.00

Packaging

Ensure copy of NDT results attached to work order.

190

QC5- Inspect part completeness to step on W/O

0.00

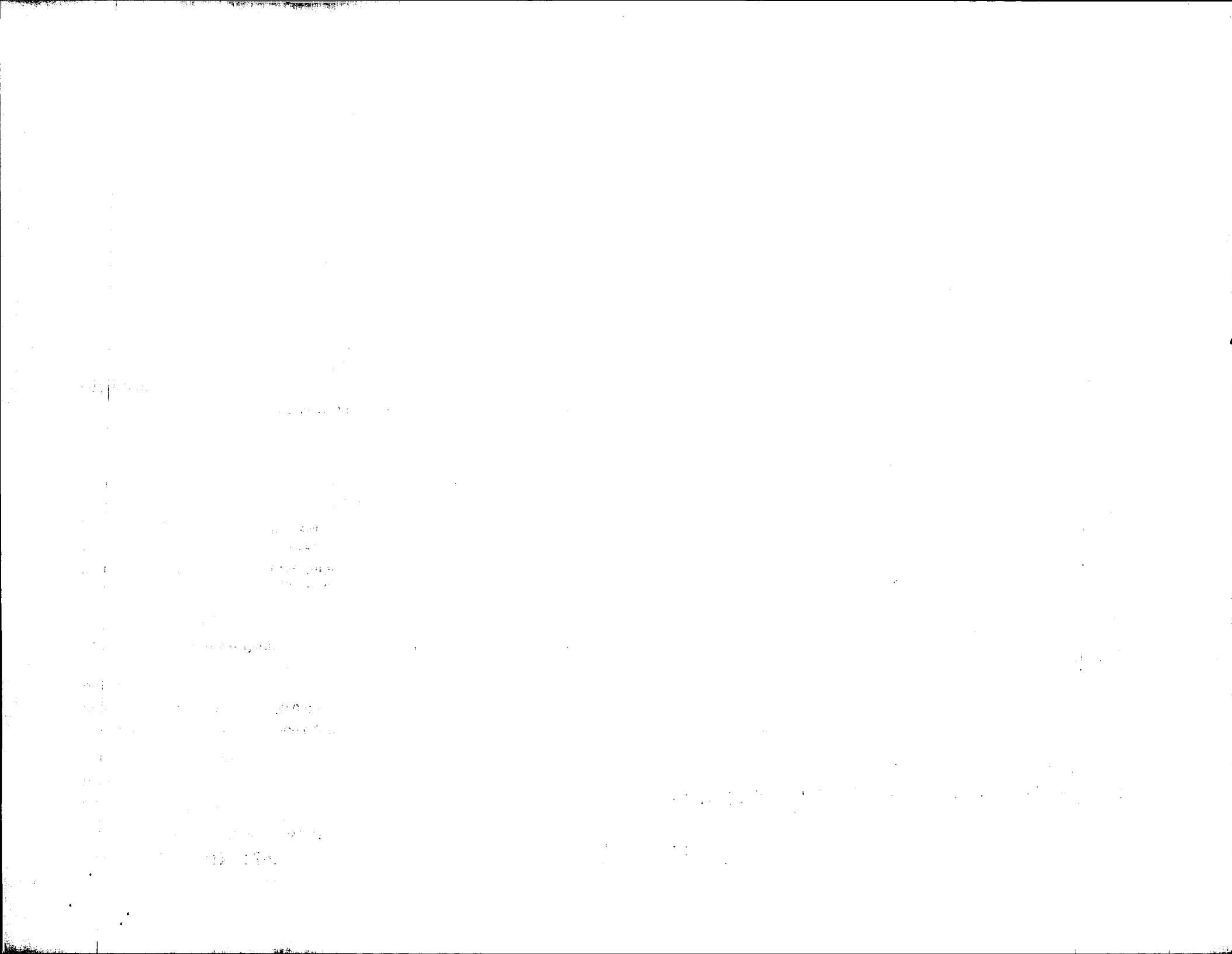
QC

Memo

0.00

Quality Control

Inspect for damage &amp; ensure results are as per Dwg D212-664-141



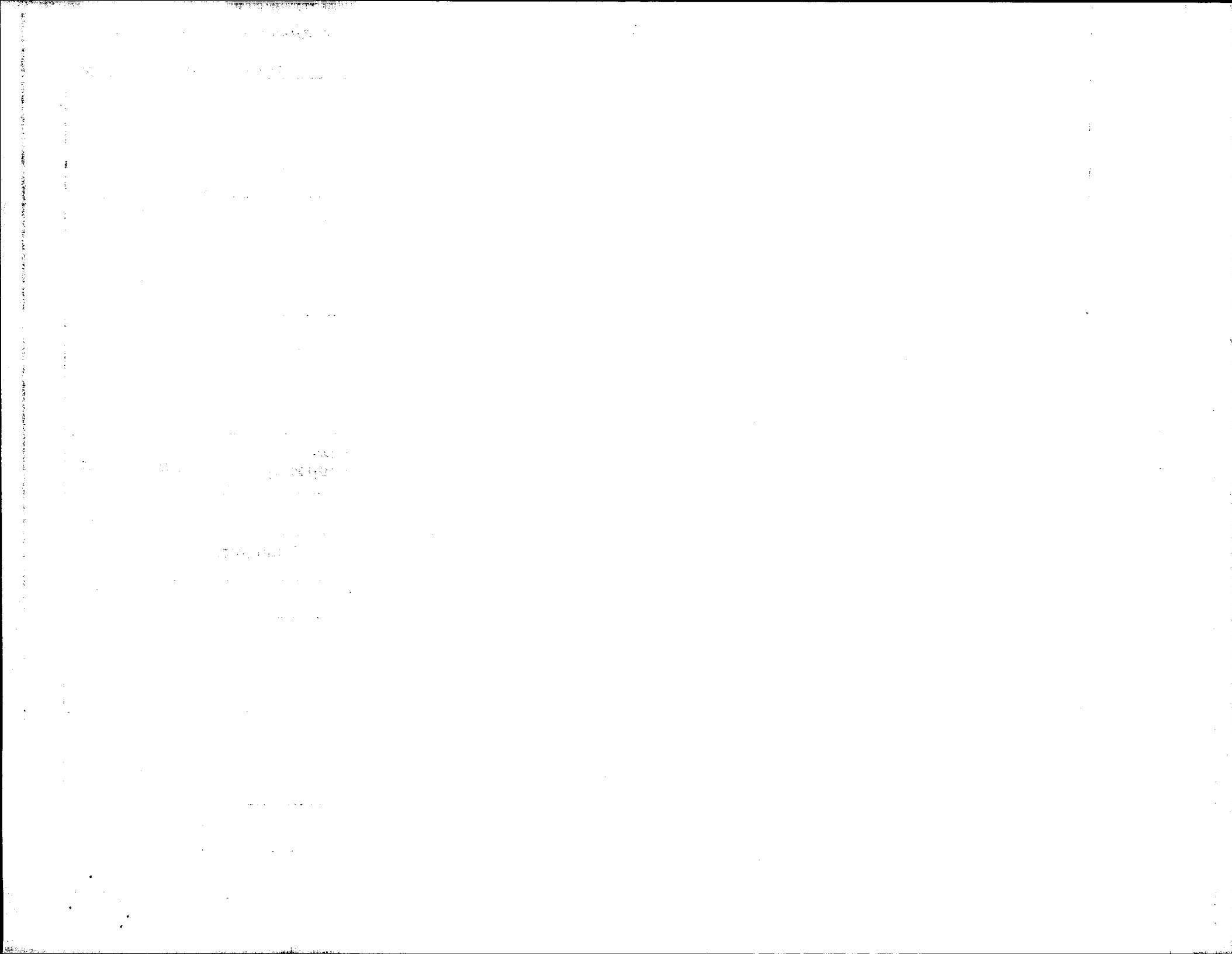
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



**Work Order ID** 72971

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Item ID: D212-664-101

Accept



Setup Start



Revision ID:

Item Name: Crosstube Fwd

Stop



Start Date: 8/23/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 9/7/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

**Sequence ID/  
Work Center ID****Operation  
Description****Set Up/  
Run Hours****Tool ID****Tool #****Plan  
Code****Accept  
Qty****Reject  
Qty****Reject  
Number****Insp.  
Stamp**

200

Spray Painting per QSI005 4.2

0.00



SprayPaint

**Memo**

0.00

Spray Painting

1-Prime inside and outside crosstube as per QSI 005 4.2

2-Paint outside crosstube as per DEO D212-667-141 with White Imron as per  
QSI 005 4.2**PRIME:**

Start Time:

11-09-19

Finish Time:

85 11-09-20

**PAINT:**

Start Time:

11-09-20

Finish Time:

210

QC14- Inspect Spray Paint

0.00

**Memo**

0.00

Quality Control

Then, Wrap in plastic bag to protect from scratches

✓ 11-09-21 (1)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date &amp; initial all entries

**-Work Order ID 72971**

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Item ID: D212-664-101

Accept



Setup Start



Revision ID:

Item Name: Crosstube Fwd

Stop



Start Date: 8/23/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 9/7/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

220



Crosstubes

0.00

*m* 11 08 22 01

Crosstubes

Memo

0.00

1-Abrade mating surfaces of support and crosstube with 400 grit sandpaper,  
clean the area with 4105S wash 'n' wipe2-Install supports with Proseal 890 per DS19563 and QSI 015  
A/R Proseal 890 Batch: *19234*3- Torque bolts as per dwg - *m 11-09-27*

230



QC6- Inspect dimensions to drawing

0.00

*Sulabz*

*④*

QC

Memo

0.00

240



Pick Kit

0.00

*11-09-27*

Packaging

Memo

0.00

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

#### （六）评价与展望

193 - 1 - 1

1928-1930

background

• 14 •

313

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

# Picklist Print

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Page 1  
3

Work Order ID: 72971



Parent Item: D212-664-101



Parent Item Name: Crosstube Fwd

Start Date: 8/23/2011

Required Date: 9/7/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:E 04.02.161 |Reformat|KJ/DS

IPP Rev:F 06-03-29 Remove Comments on Pick List JLM

IPP Rev:G 07-04-30 As per Rev C JLM IPP Rev:H

11.04.26 inspection strip ecn 11-549 EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D212-664-101TRN



Manufactured

No

B73607

110

Each

4.0000



SAD 11-09-14

Crosstube Turning Detail

Location	Loc Qty	Loc Code
----------	---------	----------

FG046 3

71645 1

72721 1

72722 1

LG 1

71646 1

D3595-063-450



Manufactured

No

230

Each

70.5600



4.210526

RUBBER CUSHION

Location	Loc Qty	Loc Code
----------	---------	----------

LG 70.56

67353 3

68893 6

70113 0.56

71354 61



W 11-09-22

B# 72967



W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Picklist Print**

Tuesday, August 23, 2011 8:12:04 AM

Page 2

Work Order ID: 72971



Parent Item: D212-664-101



Parent Item Name: Crosstube Fwd

Start Date: 8/23/2011

Required Date: 9/7/2011

Start Qty: 1.00

Required Qty: 1.00

MS21920-25



Purchased

No

220

Each

98.0000

4

4



Clamp(per MIL-DTL-8783C)

W 11.09.22

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
LG	92	
113281	0	
113282	0	
118142	42	
<u>118183</u>	50	
LG050	6	
116264	2	
117998	4	

D2893-1



2.75 Support

D3428-1



Placard

AN6-35A



BOLT

Manufactured

No

220

Each

0.0000

2

2

W 11.09.22

Manufactured

No

240

Each

20.0000

1

1

S

Purchased

No

240

Each

75.0000

4

4

11.09.22

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST053	20	
71168	8	
72048	12	
ST343	75	
117441	2	
117872	23	
118422	.50	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
	S							

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

Tuesday, August 23, 2011 8:12:04 AM

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Work Order ID: 72971



Parent Item: D2I2-664-101



Parent Item Name: Crosstube Fwd

Start Date: 8/23/2011

Required Date: 9/7/2011

Start Qty: 1.00

Required Qty: 1.00

AN6-36A



Bolt

Purchased

No

240

Each

71.0000

4

4



*S*

Location

Loc Qty

Loc Code

ST343

71

117441

1

118012

20

118422

50

MS21042L6



Nut

Purchased

No

240

Each

304.0000

6

*S*

Location

Loc Qty

Loc Code

ST300

304

117677

200

118078

4

118384

100

AN960JD616



Washer

NAS1149D0663J



Purchased

No

240

Each

0.0000

18

*18*  
49.62 11179.77



Tuesday, August 23, 2011 8:12:05 AM

Shop Packet Print

Page 3

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

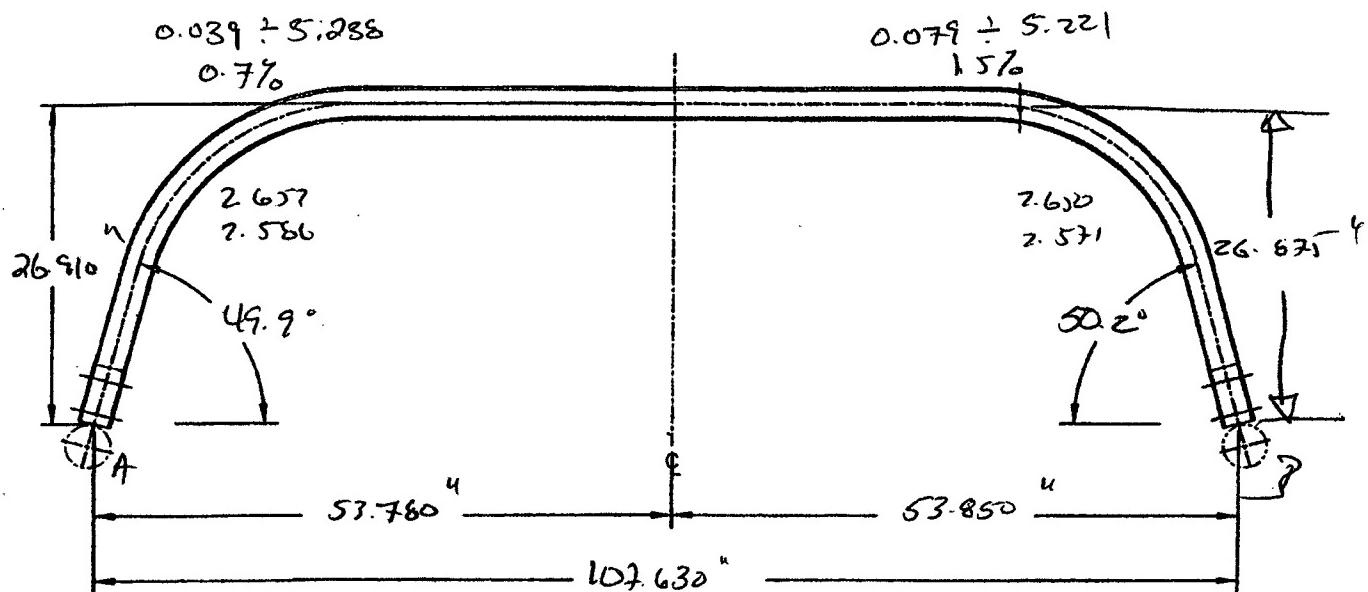
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DART AEROSPACE LTD	Work Order:	729-21
Description: Crosstube High Fwd (205/212/412)	Part Number:	D212-664-101
Inspection Dwg: D212-664-141 Rev: D		Page 1 of 1

Required Dimension	Min	Max
Height	26.79	27.05
1/2 Span	53.59	53.85
Angle	49	52
Total Span	107.18	107.7



Comments	
SIDE A = 0.7% crushin	@ 10 passes
SIDE B = 1.5% crushin	@ 16 passes

QC15 Inspection	S
Date	11/01/09

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	
B	07.05.31	Dimensions updated per Dwg Rev C	KJ/JM	
C	10.04.01	Dwg Rev updated	KJ	J

8 7 6 5 4 3 2 1

D

Item	Qty -141	Qty -141B	Part Number	Description
1	X		D212-664-141	CROSSTUBE ASSEMBLY (205/212/412 HIGH FWD)
2		X	D212-664-141B	CROSSTUBE ASSEMBLY (214 HIGH FWD)
3	1	1	D6005-128	CROSSTUBE
4	2	2	D2893-1	SUPPORT
5	4	4	D3595-063-450	RUBBER CUSHION
6	4	4	MS21920-25	CLAMP (OR MS21920-26)
7	A/R	A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)

**GENERAL NOTES:**

- 1) MATERIAL: MANUFACTURED FROM D6005-128  
FINISHED LENGTH = 128.514±0.020
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2  
PAINT OUTSIDE PER DART QSI 005 4.2
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: SCRIBE DART PART NUMBER "D212-664-XXX" AND BATCH NUMBER ON INSIDE OF CUFF  
USING VIBRATING STYLUS
- 7) WEIGHT: D212-664-141 = 33.6 lbs (PER IIN-D212-664)  
D212-664-141B = 33.6 lbs (PER IIN-D212-664)
- 8) PART IS SYMMETRIC ABOUT CENTERLINE.
- 9) RUN CUTTER OFF PART. BLEND OUT EDGE LONGITUDINALLY. TRANSITION SHOULD BE SMOOTH.
- 10) BEND PROGRESSIVELY WITH A MINIMUM OF 3 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS  
6% BASED ON O.D.
- 11) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 12) INSTALL D2893-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 TO THE SURFACE OF  
D2893-1 THAT WILL BE IN CONTACT WITH THE CROSSTUBE PER QSI 015. LET CURE FOR 12 HOURS AFTER  
INSTALLATION AND PRIOR TO PACKAGING.
- 13) INSTALL MS21920-25 CLAMPS (OR -26) WITH D3595-063-450 RUBBER CUSHIONS TO SECURE THE D2893-1  
SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMPS ARE OPPOSITE OF CROSSTUBE  
SUPPORT.
- 14) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE  
SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR  
DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND  
MARKS ARE UNACCEPTABLE.
- 15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT  
HAS NOT BOTTOMED-OUT AFTER TORQUING.

SHOP CRAFT

RETURN TO

ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NU 22921

211-08-23

REMOVED FROM UNDER REVIEW PER  
UNDER REVIEW DGN 11-2004

IIN 1105.17

FOR PRINTING START

EX0726

DEO ATTACHED

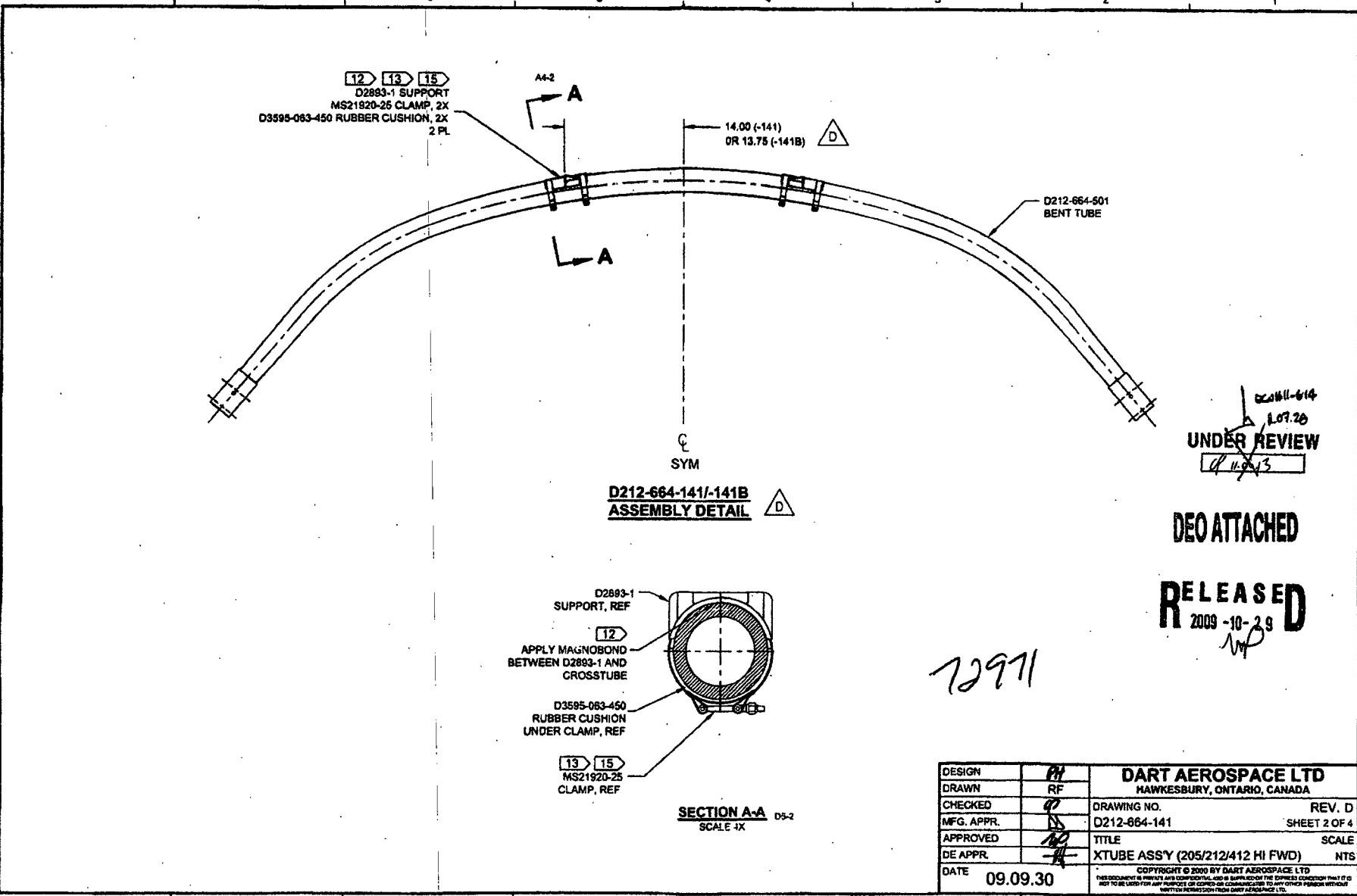
RELEASED  
2009-10-29

D	REFORMAT/REVISE GENERAL NOTES/PART LIST; REORGANIZED VIEWS AND REFORMATTED DRAWING TO CURRENT STANDARDS; ADD -141B (ZN B4-2, D4-2); REMOVED REF & ADD TOLERANCES (ZN B4-3, C6-3, C8-3 & B6-2); RELOCATED FLAG #6 PER PAR 08-046 (ZN A5-3); MOVED TURNING DETAIL & UPDATED TOLERANCE TO SHEET 4	RF	09.09.30
C	REMOVE .851 ABRASION STRIP; ADD MAGNOBOND 6398, CUSHION, REVERSE CLAMPS	PH	07.03.08
B	ADD HOLES FOR COMPATABILITY WITH BHT/AA SKIDTUBES	PH	05.02.04
A	NEW ISSUE	PH	00.12.12
REV.	DESCRIPTION		
DESIGN	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	RF		
CHECKED	P		
MFG. APPR.	D		
APPROVED	D		
DE APPR.	D		
DATE	09.09.30		
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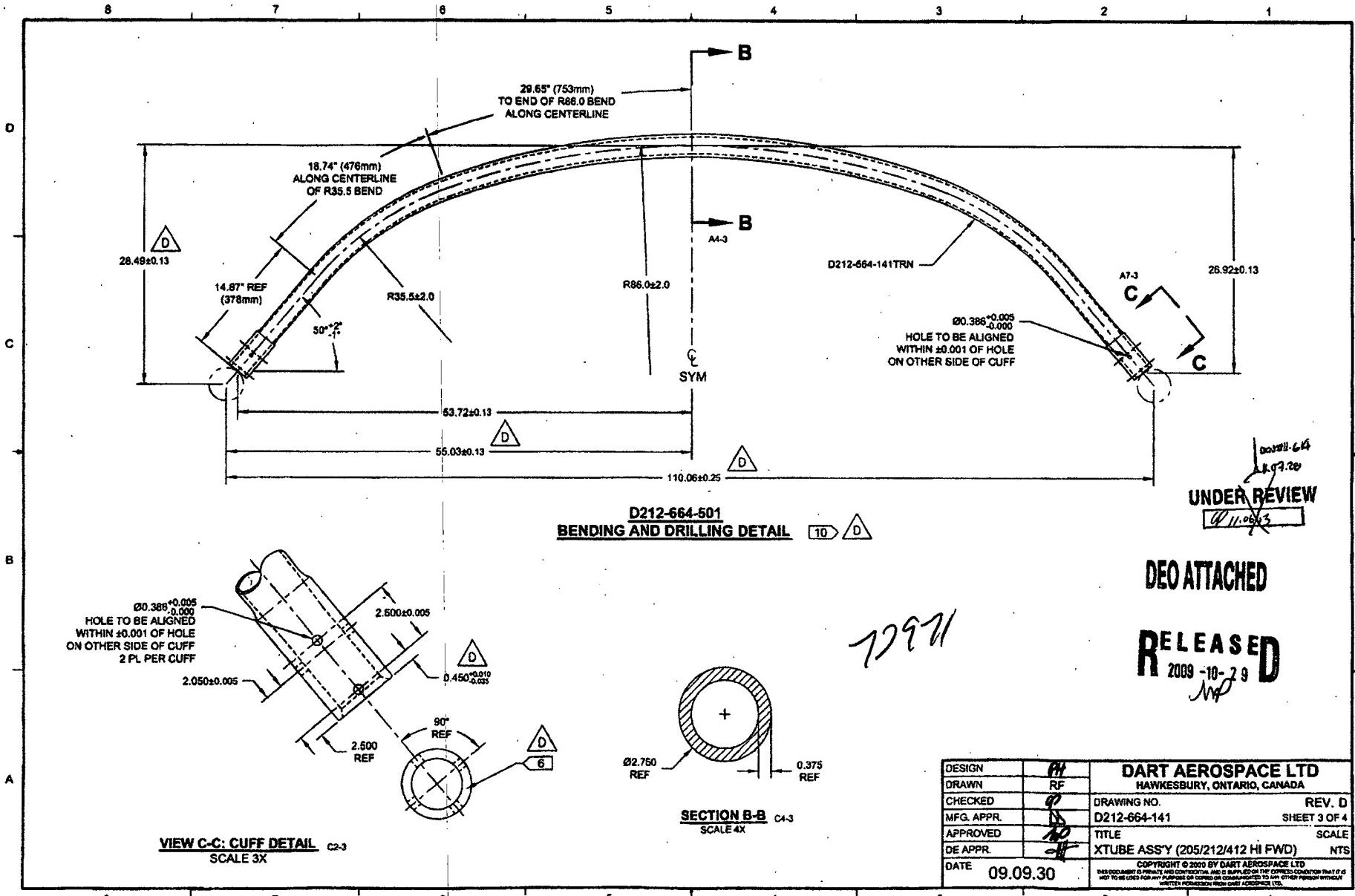
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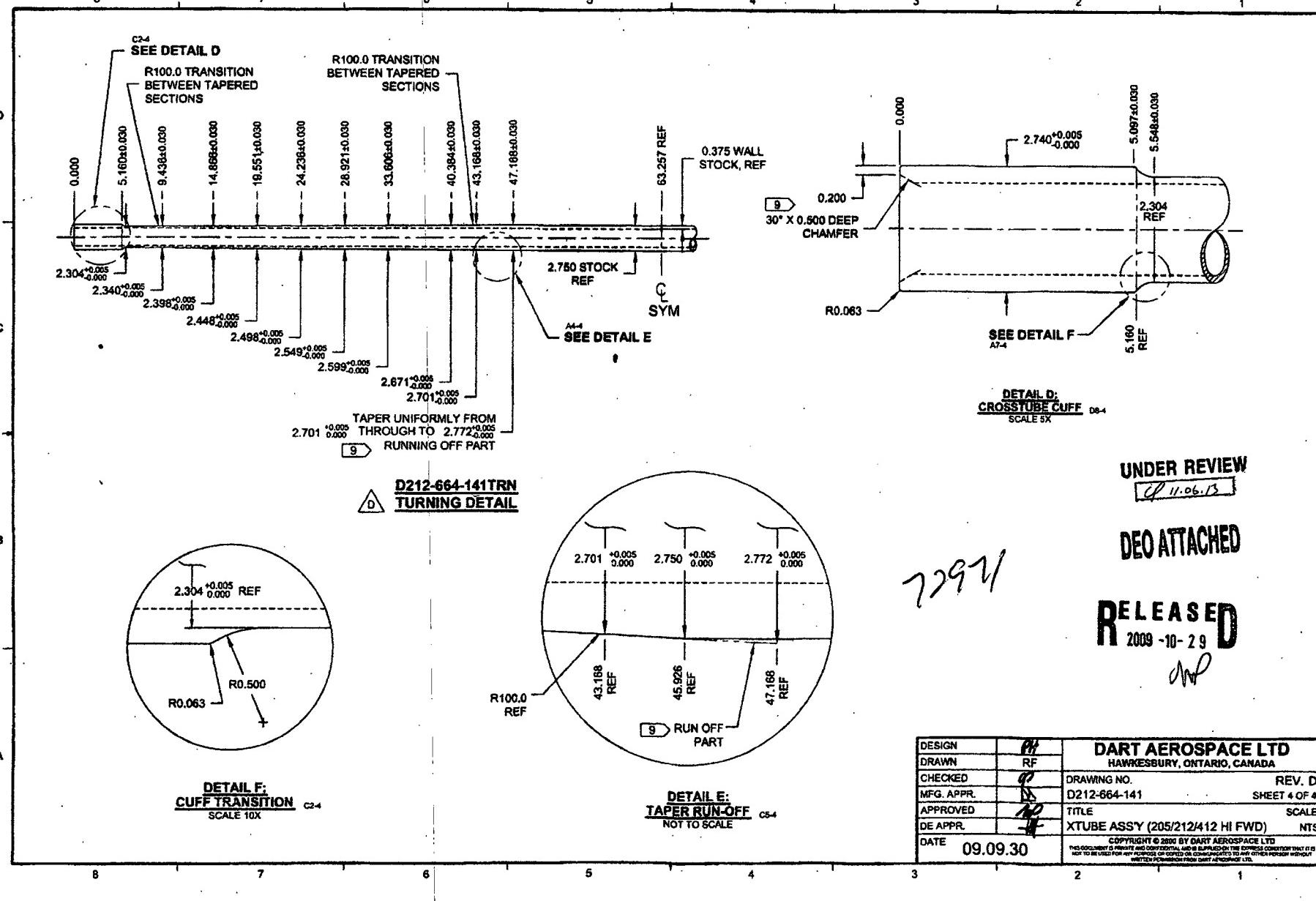
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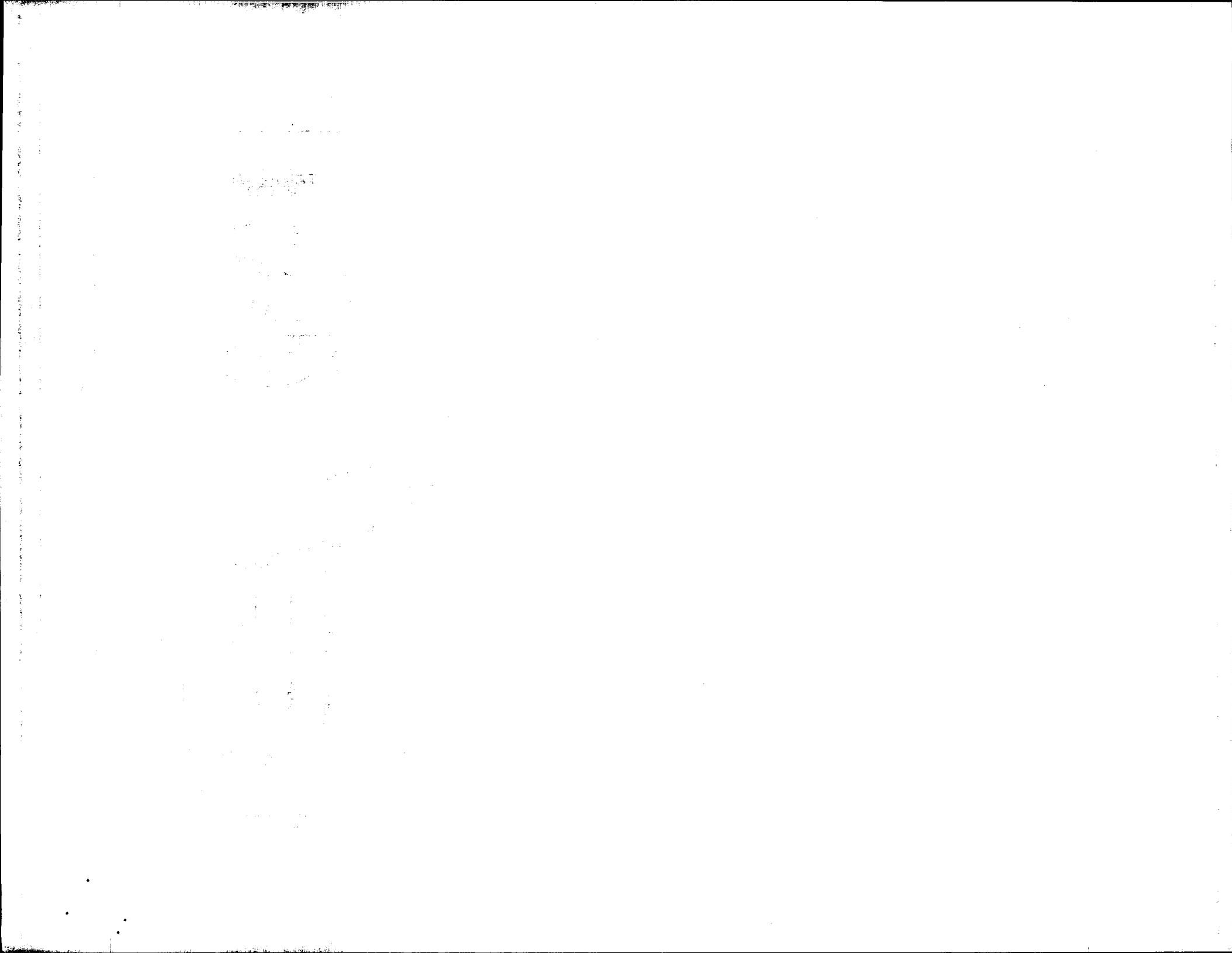




DESIGN	PH	DART AEROSPACE LTD
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA
CHECKED	00	DRAWING NO. REV. D
MFG. APPR.	DD	D212-664-141 SHEET 2 OF 4
APPROVED	100	TITLE SCALE
DE APPR.	100	XTUBE ASSY (205/212/412 HI FWD) NTS
DATE	09.09.30	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PROPRIETARY AND CONFIDENTIAL AND IS SUPPLIED UNDER THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE WRITTEN CONSENT OF DART AEROSPACE LTD.







DRAWING NO. D212-664-141	TITLE XTUBE ASSY (205/212/412 HI FWD)	REV. D	DART AEROSPACE LTD ENGINEERING ORDER	D.E.O. NO. D212-664-141-D-1	SHEET NO. SHEET 1 OF 2	SCALE NTS
DRAWN	CHECKED	OP	MFG. APPR.	APPROVED	DE APPR.	
DATE 11.04.07	DATE 11.04.11	DATE 11.04.12	DATE 11.04.12	DATE 11.04.12	DATE 11.04.12	

PURPOSE:  
ADD AN INSPECTION WINDOW TO UNDERSIDE OF CROSSTUBE.

CHANGE:

NOTES 2 OF SHEET 1 IS AMENDED AS FOLLOWS:

IS:

- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
 PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2  
 MASK UNDERSIDE OF CROSSTUBE AS SHOWN (HATCHED AREA) AND  
 PAINT OUTSIDE PER DART QSI 005 4.2  
 REMOVE MASKING AND APPLY CLEAR COAT

WAS:

- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
 PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2  
 PAINT OUTSIDE PER DART QSI 005 4.2

RELEASED  
R 2011-04-18

UNDER REVIEW

14/06/13  
12/05/16-614  
11.07.28

72911

DRAWING NO. D212-664-141	TITLE XTUBE ASSY (205/212/412 HI FWD)	REV. D	DART AEROSPACE LTD ENGINEERING ORDER	D.E.O. NO. D212-664-141-D-1	SHEET NO. SHEET 2 OF 2	SCALE NTS
DRAWN DATE 11.04.07	CHECKED OP DATE 11.04.11	MFG. APPR. E DATE 11.04.12	APPROVED WD DATE 11/04/12	DE APPR. H DATE 11.04.12		

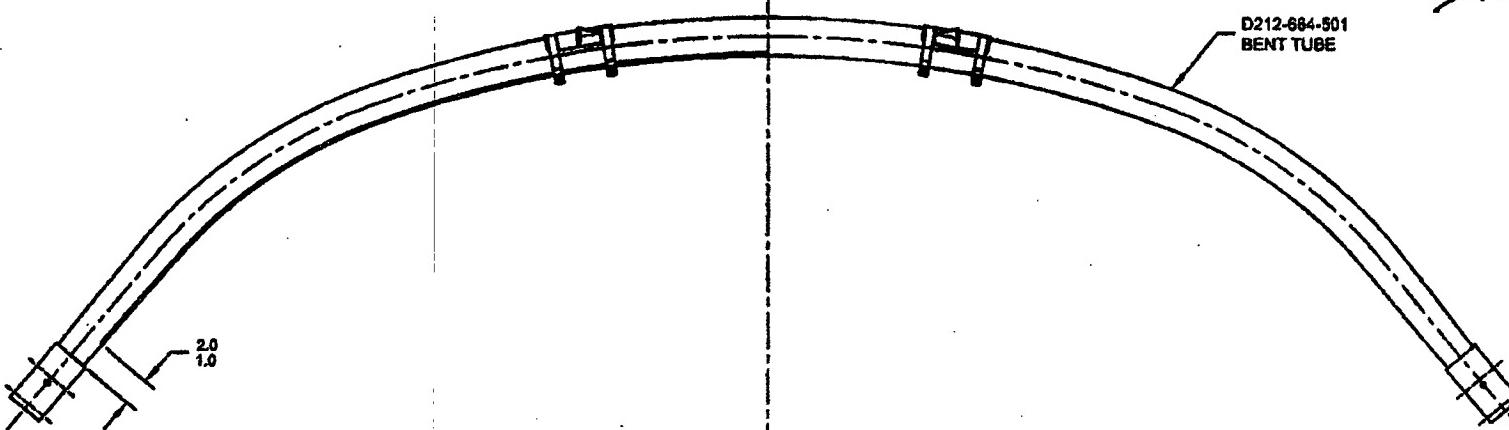
**UNDER REVIEW**

~~GP 11/06.13~~

ECM#H-614  
11.07.28

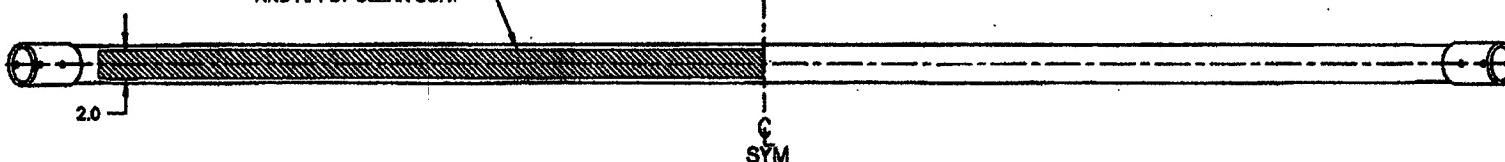
IS:

WAS:



**D212-664-141/-141B  
ASSEMBLY DETAIL**

72971



DRAWING NO. D212-664-141	TITLE CROSSTUBE ASS'Y (205 HI FWD)	REV. D	DART AEROSPACE LTD ENGINEERING ORDER	D.E.O. NO. D212-664-141-D-2	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>10</i>	CHECKED <i>A/S</i>		MFG. APPR. <i>AS</i>	APPROVED <i>100</i>	DE APPR. <i>SM</i>	
DATE 11.07.15	DATE 11.07.20		DATE 11.07.21	DATE 11/07/21	DATE 11.07.21	

**PURPOSE:**  
REPLACE MAGNOBOND WITH PROSEAL.

**CHANGE:**

IS:

Item	Qty -141	Qty -141B	Part Number	Description
7	A/R	A/R	PROSEAL 890 B-2	SEALANT, AMS-S-8802 CLASS B-2

WAS:

7	A/R	A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)
---	-----	-----	----------------	---------------------------------------------------------------------------------------------------------------

NOTE 12 & 15, SHEET 1 IS AMENDED AS FOLLOWS:

IS:

- 12) TO INSTALL D2893-1 SUPPORT: ABRADE MATING SURFACE OF SUPPORT AND CROSSTUBE WITH 180-GRIT SANDPAPER AND REMOVE RESIDUE WITH MEK (OR EQUIVALENT). APPLY A 0.04" TO 0.07" THICK LAYER OF PROSEAL 890 CLASS B-2 (OR AMS-S-8802 CLASS B-2) SEALANT TO MATING SURFACE OF SUPPORT.
- 15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING. PRIOR TO PACKAGING, RE-CHECK TORQUE ON CLAMPS AFTER PROSEAL 890 SEALANT HAS CURED FOR 72 HOURS.

WAS:

- 12) INSTALL D2893-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 TO THE SURFACE OF D2893-1 THAT WILL BE IN CONTACT WITH THE CROSSTUBE PER QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

7297  
TEKAS 2011-07-28

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# LIQUID PENETRANT TEST REPORT

P- 12240

CLIENT	<u>DART AEROSPACE</u>	DATE	<u>SEPT 10-2011</u>	PAGE	<u>1</u>	OF	<u>1</u>
ATTENTION	<u>LINDA LACELLE</u>	ACUREN JOB NO.	<u>188 - 11 - 02359</u>	TIME	AM <input checked="" type="checkbox"/>	PM <input type="checkbox"/>	
ADDRESS	<u>1270 ABERDEEN ST.</u>	PO/WO No.	<u>14914 -</u>	WORK LOCATION	<u>HAWKES BURY ON T.</u>		
PROJECT				ACCEPTANCE STD.	<u>ASTM 1417/BSI -</u>	REV./DATE	<u>2005</u>
ITEM(S) EXAMINED				(8)			

JOB DESCRIPTION	PROCEDURE NO. LT- <u>002</u> REV./DATE <u>2008</u>	TECHNIQUE NO. LT- <u>1442</u> REV./DATE <u>2005</u>	
PART NO.	MATERIAL <u>Aluminum</u> THICKNESS <u>—</u>		
SCOPE	<u>WET FLUORESCENT LIQUID PENETRANT INSPECTION</u> <u>CARRIED OUT ON 100% EXTERNAL SURFACE.</u>		

TEST DETAILS							
METHOD	<input checked="" type="checkbox"/> FLUORESCENT	<input type="checkbox"/> VISIBLE	<input checked="" type="checkbox"/> WATER WASH	<input type="checkbox"/> SOLVENT REMOVABLE	<input type="checkbox"/> POST EMULSIFIED		
FAMILY BRAND	<u>ULTRAFUX</u>		BLACK LIGHT S/N <u>16459</u>	OUTPUT > 1000 $\mu$ W/cm <sup>2</sup>	AMBIENT < 2 fc		
PENETRANT	<u>Z-107</u>	MINIMUM DWELL TIME <u>45</u> MIN.	LIGHTING EQUIP. <input type="checkbox"/> FLASHLIGHT <input type="checkbox"/> TROUBLELIGHT	<input type="checkbox"/> OUTPUT > 100 fc @ SURFACE			
PENETRANT REMOVER	<u>H2O</u>	MINIMUM DRY TIME <u>&gt;10</u> MIN.	OTHER				
DEVELOPER	<u>SKO 52</u>	MINIMUM DWELL TIME <u>10</u> MIN.	LIGHT METER S/N <u>1098866</u>	CAL DUE DATE			<u>FEB - 02 - 2012</u>
DEVELOPER TYPE	<input checked="" type="checkbox"/> NON AQUEOUS	<input type="checkbox"/> AQUEOUS	<input type="checkbox"/> DRY				

SURFACE CONDITION	<input type="checkbox"/> AS GROUND	<input type="checkbox"/> AS WELDED	<input checked="" type="checkbox"/> MACHINED	<input type="checkbox"/> SHOT BLASTED	<input checked="" type="checkbox"/> CLEAN BARE METAL
SURFACE TEMPERATURE	<input type="checkbox"/> < -4°C/20°F	<input type="checkbox"/> -4°C/20°F TO 10°C/50°F	<input checked="" type="checkbox"/> 10°C/50°F TO 52°C/125°F	<input type="checkbox"/> > 52°C/125°F	

RESULTS- <input checked="" type="checkbox"/> METRIC <input type="checkbox"/> IMPERIAL	
---------------------------------------------------------------------------------------	--

1 CLASS TUBE-W.O. <u>71747</u>	<input checked="" type="checkbox"/>	
2 CLASS TUBE-W.O. <u>73043</u>	<input checked="" type="checkbox"/>	
1 CLASS TUBE-W.O. <u>73044</u>	<input checked="" type="checkbox"/>	
2 CLASS TUBE-W.O. <u>71748</u>	<input checked="" type="checkbox"/>	
1 CLASS TUBE-W.O. <u>72971</u>	<input checked="" type="checkbox"/>	
2 CLASS TUBE-W.O. <u>72970</u>	<input checked="" type="checkbox"/>	
1 CLASS TUBE-W.O. <u>71376</u>	<input checked="" type="checkbox"/>	
1 CLASS TUBE-W.O. <u>71375</u>	<input checked="" type="checkbox"/>	

Scope of Services			
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The agreement of Acuren Group Inc. to perform services extends only to those services provided for in writing. Under no circumstances shall such services extend beyond the performance of the requested services. It is expressly understood that all descriptions, comments and expressions of opinion reflect the opinions or observations of Acuren Group Inc. based on information and assumptions supplied by the owner/operator and are not intended nor can they be construed as representations or warranties. Acuren Group Inc. is not assuming any responsibilities of the owner/operator and the owner/operator retains complete responsibility for the engineering, manufacture, repair and use decisions as a result of the data or other information provided by Acuren Group Inc. In no event shall Acuren Group Inc.'s liability in respect of the services referred to herein exceed the amount paid for such services.

#### Standard of Care

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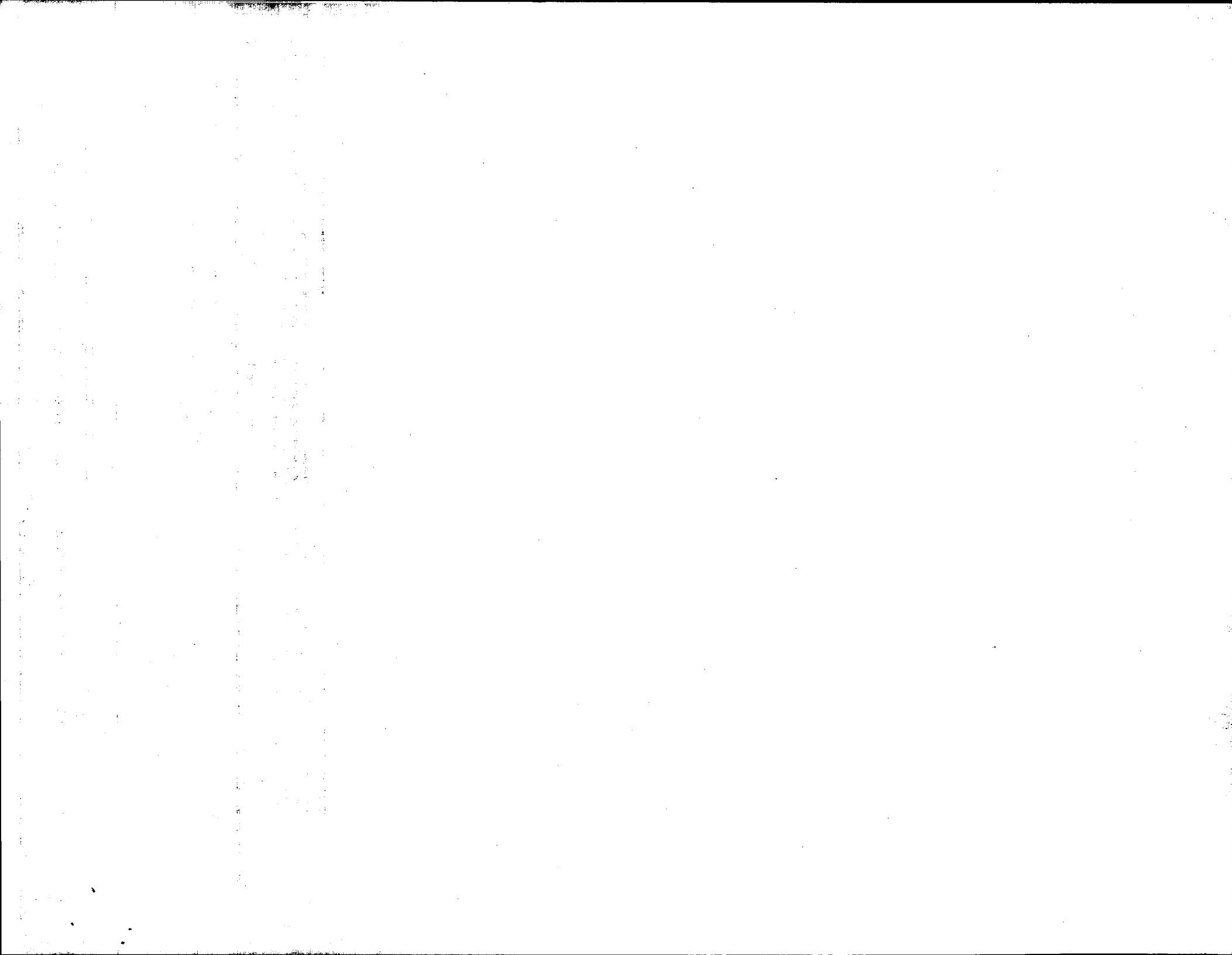
SIGNATURES			
CLIENT REPRESENTATIVE	<u>Ian Titter</u>	<u>Tan Titter</u>	DTR # <u>E-63683</u>
TECHNICIAN (SIGNATURE):			
NAME (PRINT):	<u>ST. KEITH TITTER</u>	<u>ST. KEITH TITTER</u>	REPORT REVIEWED BY:
CGSB LEVEL	<u>SNT LEVEL</u>	2 <sup>nd</sup> TECHNICIAN CGSB LEVEL <u>6606</u>	NAME <u></u> INITIALS <u></u>
CGSB REG. NO.	<u>6606</u>	CGSB REG. NO. <u></u>	

WHITE - CLIENT COPY

CANARY - OFFICE COPY

PINK - TECHNICIAN COPY

GOLD - OFFICE COPY





**Packing Slip:Return E**

**Ship From:** Falcon Aviation  
Al Bateen Airbase, Airport Road  
Abu Dhabi, U.A.E.  
Steve McComish  
Tel #011 971 48860470

**Ship To:** Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
Canada  
Tel # 1.613.632.5200  
GST # RT101272607

**Date:** April 16, 2012

**P.O. #:** Return

**Ship Via:** Journey

**FOB:**

Item	Part Number / Product Description	Qty. Ordered	Qty. Shipped	Qty. Back Order
1	D212-664-101 Crosstube Batch 72971	1	1	0
2				
3				
4				
5				
6				
7	Parts Made In Canada being returned for evaluation			

**Dart Aerospace Ltd.**  
**1270 Aberdeen Street**  
**Hawkesbury, ON K6A 1K7**  
**Canada**  
**Tel.: 1.613.632.5200**  
**Fax: 1.613.632.1185**  
**GST # RT101272607**

**Commercial Invoice: Return E**

**Ship From:** Falcon Aviation  
Al Bateen Airbase, Airport Road  
Abu Dhabi, U.A.E.  
Steve McComish  
Tel # 011 971 48860470

**Ship To:** Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
Canada  
Tel # 1.613.632.5200  
GST # RT101272607

**Date:** April 16, 2012

**P.O. #:** Return

**Ship Via:**Journey

**FOB:**

Item	Part Number / Product Description	Tariff Class.	Quantity	Unit Price	Total
1	D212-664-101 Crosstube Batch 72971	8803.20	1	\$ 6,804.00	\$ 6,804.00
2					\$ -
3				\$ -	\$ -
4				\$ -	\$ -
5				\$ -	\$ -
6				\$ -	\$ -
7	Parts being returned for evaluation			\$ -	\$ -

**All Prices are in US Dollars**

**All of the above parts were made in Canada unless otherwise indicated**  
**THIS IS A CUSTOMS INVOICE ONLY**

Sub Total \$6,804.00

Total \$6,804.00

**Amount Due: \$6,804.00**

Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
Canada  
Tel.: 1.613.632.5200  
Fax: 1.613.632.1185  
GST # RT101272607